

Work Order ID 97781-2

February-25-13 8:37:29 AM

97781

Page 1

Item ID: D3849-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Alt Wearplate Assembly, STD Gear

Start Date: 2/25/13 Start Qty: 6.00

Cust Item ID:

Required Date: 3/11/13 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: MJS

Date: 13-02-25 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3849

D

110

0.00

110

Large Fab

Large Fab

Memo

0.00

1- On D3901-1 bar, fill cut outs with hardcoat welding rod as per dwg D3849

2059 B Hardcoat Welding Rod

BATCH#: M124597

2- Weld D3901-1 bar to wearplate as per dwg D3849

304 S.S. Welding Rod

BATCH#: M118161

3- Transfer drill holes as per dwg

4- Cut excess bar material if necessary

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Quality Control

Memo

0.00

13-03-11 MAL

13-03-12

Work Order ID 97781

February-25-13 8:37:29 AM

97781

Page 2

Item ID: D3849-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Alt Wearplate Assembly, STD Gear

Start Date: 2/25/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 3/11/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

⑤ 13-03-12

DAS
09

140

0.00

140

Small Fab

Memo

0.00

Small Fab

1- Apply a layer of rockguard as per dwg

BATCH: 23887

④

Ø

Ø

AS
13-3-14

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

DAS
16
2-22

13/3/15

④

Work Order ID 97781

February-25-13 8:37:29 AM

97781

Page 3

Item ID: D3849-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Alt Wearplate Assembly, STD Gear

Start Date: 2/25/13 Start Qty: 6.00 *6*

Cust Item ID:

Required Date: 3/11/13 Req'd Qty: 6.00 *6*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*

QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

160 Identify as per dwg & Stock Location: FP-002

0.00

160

Packaging

Memo

0.00

Packaging

x 4 13/03/18

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

13/3/2018

13-03-19

Picklist Print

February-25-13 8:37:33 AM

Page 1

Work Order ID: 97781

97781

Parent Item: D3849-043

D3849-043

Parent Item Name: Aft Wearplate Assembly, STD Gear

Start Date: 2/25/13

Required Date: 3/11/13

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP RevA: New issue DD verified by:EC

IPP Rev:B

12.09.11 AS PER DWG REV.D DD VERF:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D3849-3 | | Manufactured | No | | | 110 | Each | 14.0000 | 1 | 6 | | | |
| *D3849-3* | | | | | | | | | | | | | |
| Plate | | | | | | | | | | | | | |

**

Location

Loc Qty

Loc Code

WA001

14

82673

2

90556

3

93050

3

93324

6

110

Each

26.0000

2

12

**

x4 13-03-11 MAL

D3901-3

Manufactured No

D3901-3

Bar

Location

Loc Qty

Loc Code

WA001

26

91598

4

91910

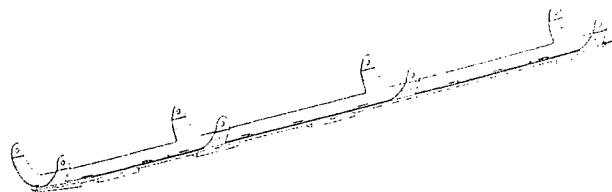
4

93306

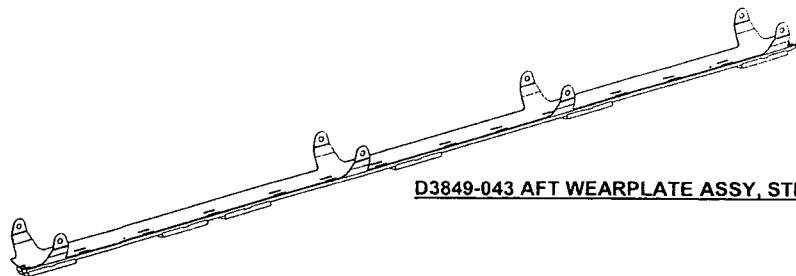
18

x8

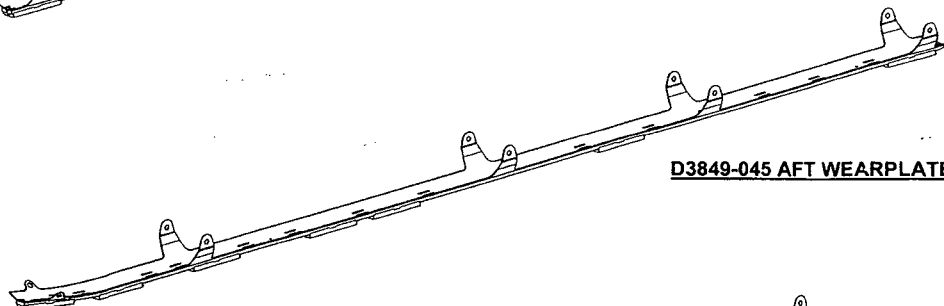
x8 13-03-11 MAL



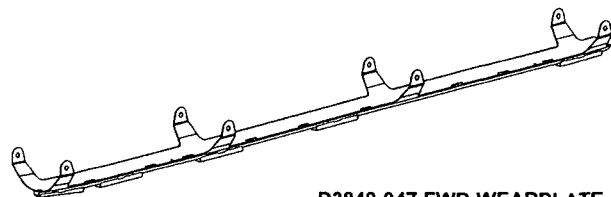
D3849-041 FWD WEARPLATE ASSY, STD GEAR



D3849-043 AFT WEARPLATE ASSY, STD GEAR



D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR



D3849-047 FWD WEARPLATE ASSY, FLOAT GEAR

| ITEM | QTY -041 | QTY -043 | QTY -045 | QTY -047 | P/N | DESCRIPTION |
|------|-------------|-------------|-------------|-------------|-----------|--------------------------------|
| 1 | X | | | | D3849-041 | FWD WEARPLATE ASSY, STD GEAR |
| 2 | | X | | | D3849-043 | AFT WEARPLATE ASSY, STD GEAR |
| 3 | | | X | | D3849-045 | AFT WEARPLATE ASSY, FLOAT GEAR |
| 4 | | | | X | D3849-047 | FWD WEARPLATE ASSY, FLOAT GEAR |
| 11 | 1 | | | | D3849-1 | PLATE |
| 12 | | 1 | | | D3849-3 | PLATE |
| 13 | | | 1 | | D3849-5 | PLATE |
| 14 | | | | 1 | D3849-7 | PLATE |
| 15 | 1 | | | 1 | D3901-1 | BAR |
| 16 | | 2 | | | D3901-3 | BAR |
| 17 | | | 2 | | D3901-5 | BAR |
| 21 | A/R | A/R | A/R | A/R | 2059B | HARDCOAT |
| 22 | A/R | A/R | A/R | A/R | 4714 | PLUS ONE ROCKGUARD |

97781 MJS
13-02-25
RELEASED
2012-09-05
JMS

| | | | |
|------------|--|----|----------|
| D | REVISED FLAT PATTERN - CHANGED SLOT LOCATIONS TO MATCH D3901-1/3/5 BARS (ZN B6-6, B3-6, B6-7, C2-7, B6-8, B2-8, B7-9, B2-9). | DC | 12.08.23 |
| C | REVISED FLAT PATTERN - CHANGE SLOT LOCATIONS. ADDED DOUBLE SLOTS AND D3901-3/5 BARS ON -043/-045. UPDATED DETAIL VIEWS. CHANGED WELD DETAILS (ZN B2-2). REMOVED D3849-11/3/5/7 GASKETS. ADD ROCKGUARD COATING. REMOVE FINISH. | DC | 12.08.21 |
| B | REVISED FLAT PATTERN 0.0375 WAS SLOT HOLE ON D3849-1F/3F/5F (ZN A4-5, B4-7, B4-8, C2-10, B2-10); ADD D3849-047 (ZN D4-1, A4-1 & B4-5) & D3849-7/7F (ZN C4-9, A4-9); ADD SECTION K-K (ZN C5-10); 0.88 WAS 0.875 & 0.44 WAS 0.438 (ZN A3-10); ADD 0.25 & 0.88 (ZN D4-10, D3-10); ADD 0.88 & 0.44 (ZN C3-10 & B3-10); ADD FLAG NOTE (ZN A8-2, C6-2, C3-2, A8-3, C6-3, C3-3, A8-4, C6-4, C2-4); 68, 87 WAS 67.36 (ZN B4-7) | RF | 09.06.30 |
| A | NEW ISSUE | RF | 09.03.30 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | | |
| DRAWN | DC | | |
| CHECKED | KS | | |
| MFG. APPR. | KS | | |
| APPROVED | KS | | |
| DE APPR. | KS | | |
| DATE: | 12.08.23 | | |

DART AEROSPACE USA, INC.
KENT, WA

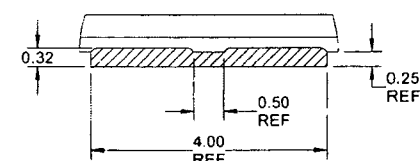
DRAWING NO. **D3849** REV. D
SHEET 1 OF 10
TITLE **WEARPLATE ASSY** SCALE NTS

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74.



C3-2



C5-2

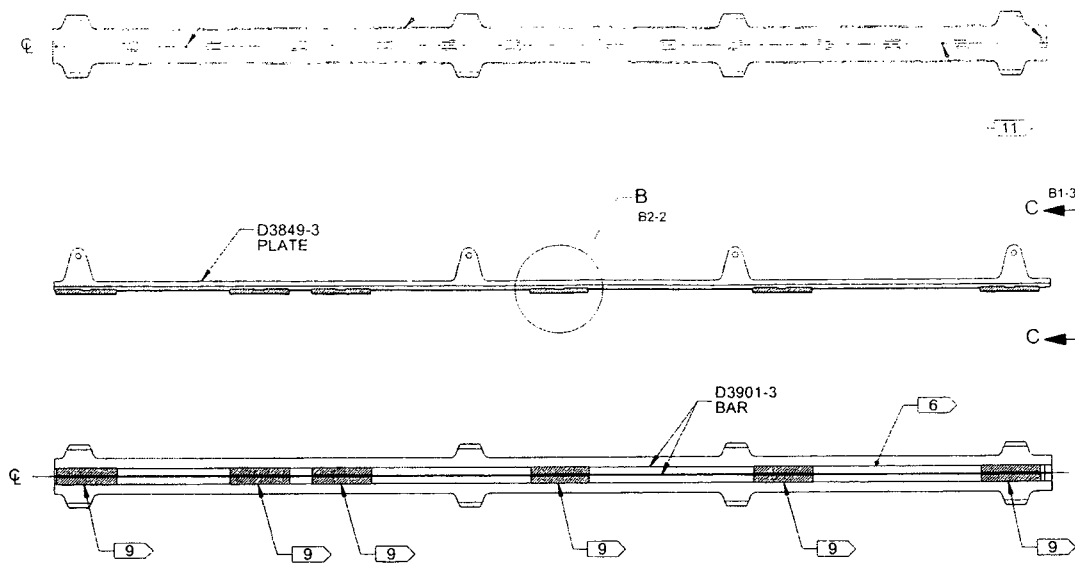
RELEASED
2012-09-04

NOTES:

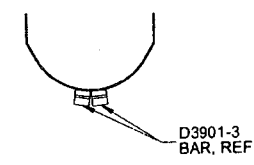
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 AS SHOWN
- 7) WEIGHT: D3849-041 = 4.58 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON LATERAL SURFACES
- 10) COAT: ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) TRANSFER DRILL Ø0.188 HOLES FROM D3849-1 PLATE TO D3901-1 BAR

| | | | |
|------------|-----------------|--|---------------|
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| DRAWN | <i>DFC</i> | KENT, WA | REV. C |
| CHECKED | <i>DFC</i> | DRAWING NO. | SHEET 2 OF 10 |
| MFG. APPR. | <i>DFC</i> | D3849 | |
| APPROVED | <i>DFC</i> | TITLE | SCALE |
| DE APPR. | <i>DFC</i> | WEARPLATE ASSY | NTS |
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97781



D3849-043 AFT WEARPLATE ASSY, STD GEAR



SECTION C-C

C3-3

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2012-09-04

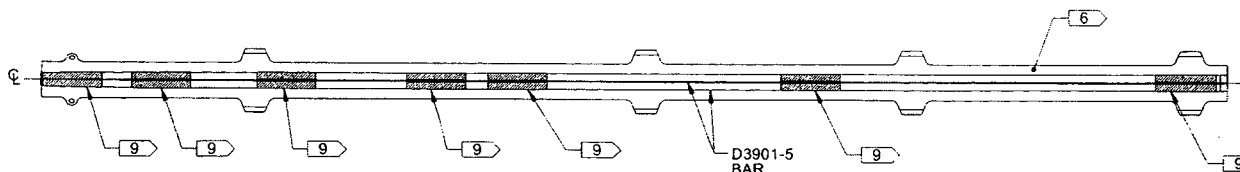
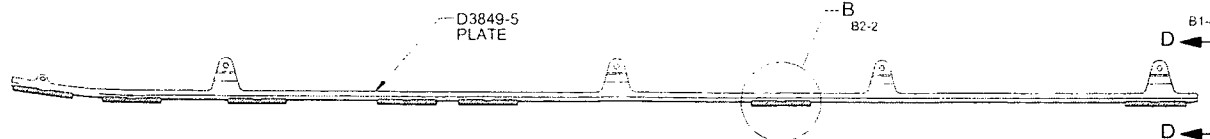
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 AS SHOWN
- 7) WEIGHT: D3849-043 = 7.66 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D3901-3 BARS ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) TRANSFER DRILL Ø0.188 HOLES FROM D3849-3 PLATE TO D3901-3 BARS

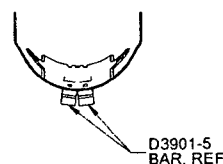
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|------------|----------|---|---------------|
| DESIGN | RF | DART AEROSPACE USA, INC. | |
| DRAWN | DC | KENT, WA | |
| CHECKED | AS | DRAWING NO. | REV. D |
| MFG. APPR. | AS | D3849 | SHEET 3 OF 10 |
| APPROVED | 149 | TITLE | SCALE |
| DE APPR. | | WEARPLATE ASSY | NTS |
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8 7 6 5 4 3 2 1

97781



D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR



SECTION D-D

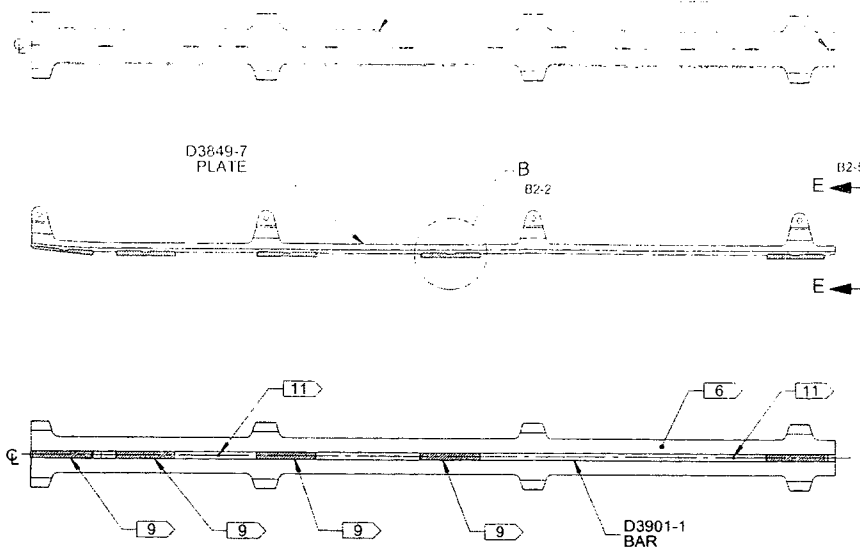
C2-4

NOTES:

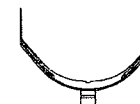
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- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 AS SHOWN
- 7) WEIGHT: D3849-045 = 8.93 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D3849-5 BARS ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) TRANSFER DRILL ϕ 0.188 HOLES FROM D3849-5 PLATE TO D3901-5 BARS

| | | | |
|------------|----|---------------------------------|-----------|
| DESIGN | RF | DART AEROSPACE USA, INC. | |
| DRAWN | BC | KENT, WA | |
| CHECKED | BC | DRAWING NO. D3849 | REV. D |
| MFG. APPR. | BC | SHEET 4 OF 10 | |
| APPROVED | BC | TITLE WEARPLATE ASSY | SCALE NTS |
| DE APPR. | BC | DATE 12.08.23 | |

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D3849-047 FWD WEARPLATE ASSY, FLOAT GEAR



SECTION E-E
C3-5

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 AS SHOWN
- 7) WEIGHT: D3849-047 = 4.60 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) TRANSFER DRILL $\phi 0.188$ HOLES FROM D3849-7 PLATE TO D3901-1 BAR

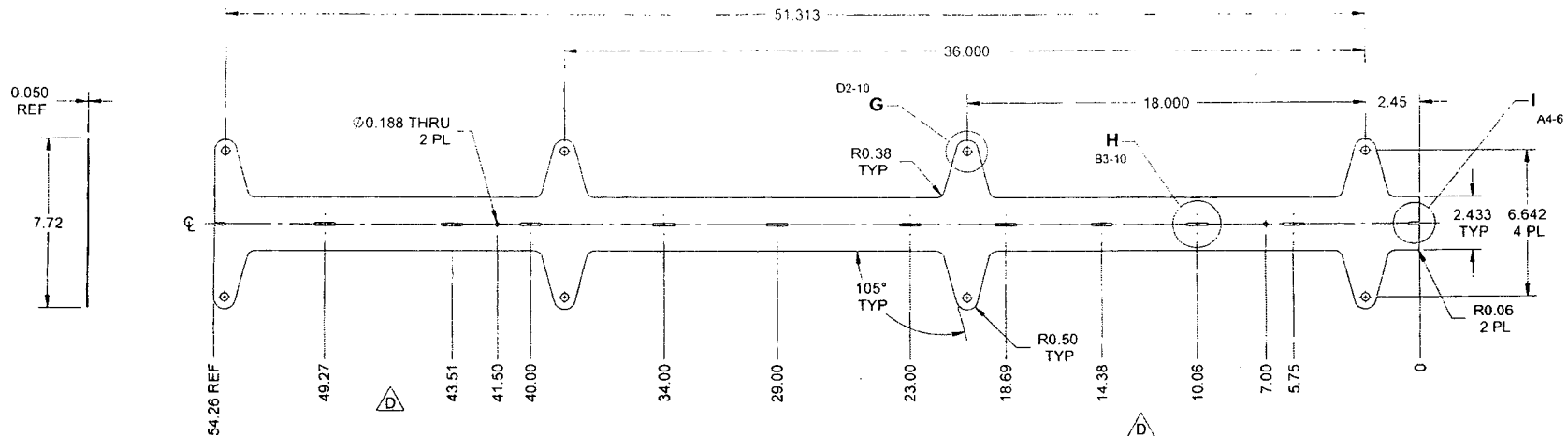
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2012-09-04

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| DRAWN | DC | KENT, WA | |
| CHECKED | DC | DRAWING NO. | REV. D |
| MFG. APPR. | DC | D3849 | SHEET 5 OF 10 |
| APPROVED | DC | TITLE | SCALE |
| DE APPR. | DC | WEARPLATE ASSY | NTS |
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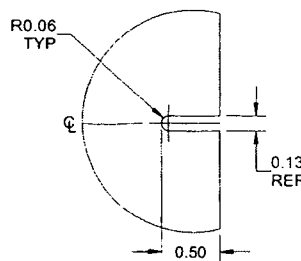
R38.5

D3849-1 PLATE
(MAKE FROM D3849-1F)

A0-10



D3849-1F FLAT PATTERN



DETAIL I

C2-6
82-9

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.30 lbs

RELEASE
2012-09-04

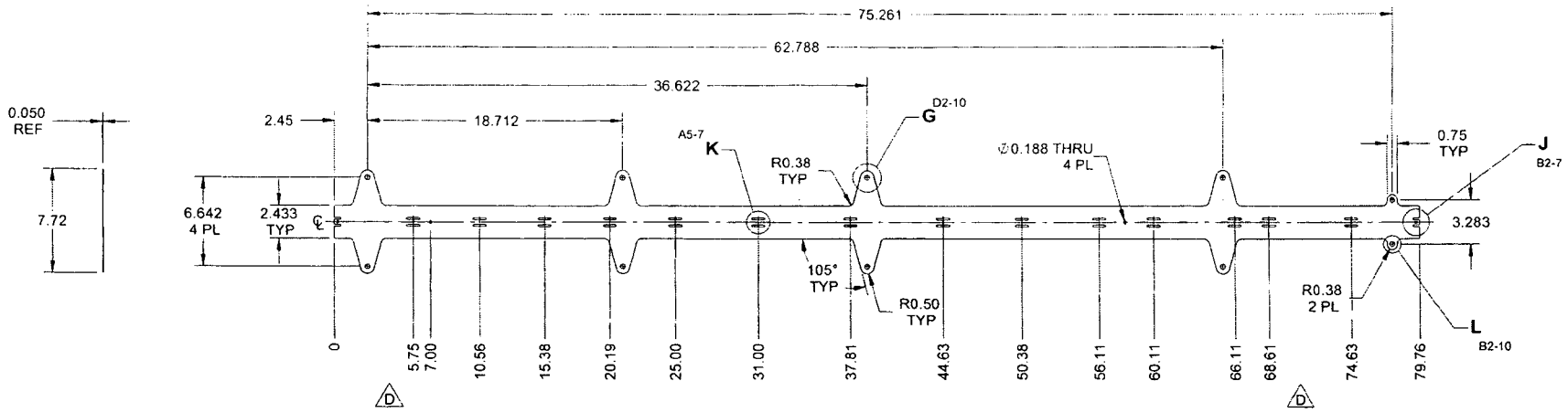
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| DESIGN | RF | DART AEROSPACE USA, INC. | |
| DRAWN | PC | KENT, WA | |
| CHECKED | PC | DRAWING NO. | REV. D |
| MFG. APPR. | PC | D3849 | SHEET 6 OF 10 |
| APPROVED | PC | TITLE | SCALE |
| DE APPR. | PC | WEARPLATE ASSY | NTS |
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97781

0.050 REF

72.6

D3849-5 PLATE
(MAKE FROM D3849-5F)



D3849-5F FLAT PATTERN

RELEASED
2012-09-04

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.17 lbs

| | | | |
|------------|----------|--|---------------|
| DESIGN | RF | DART AEROSPACE USA, INC. | |
| DRAWN | BC | KENT, WA | |
| CHECKED | JS | DRAWING NO. | REV. D |
| MFG. APPR. | JS | D3849 | SHEET 8 OF 10 |
| APPROVED | JS | TITLE | SCALE |
| DE APPR. | JS | WEARPLATE ASSY | NTS |
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97701

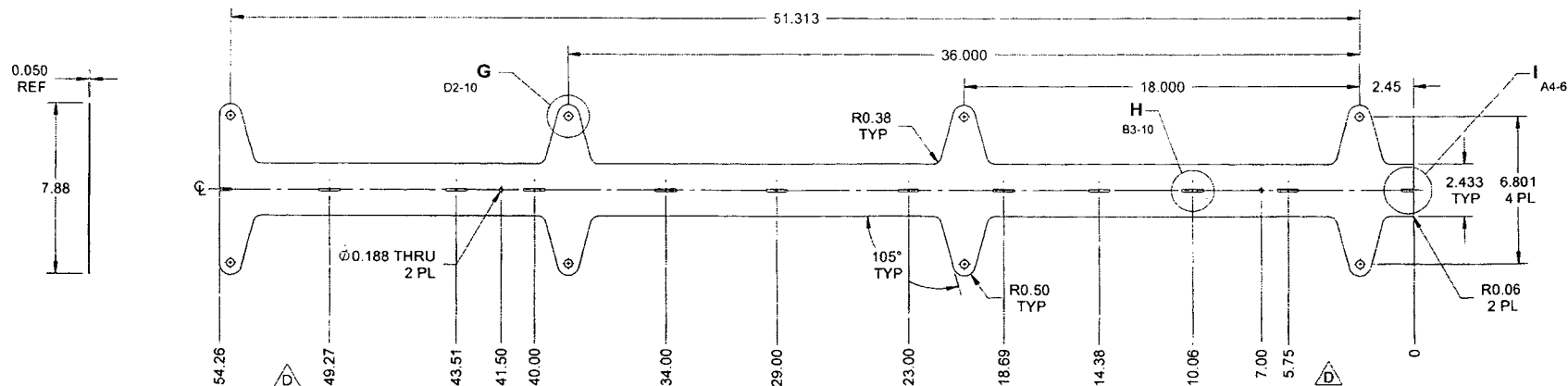
0.03 REF

R38.5

49.51

D6-10

D3849-7 PLATE
(MAKE FROM D3849-7F)



D3849-7F FLAT PATTERN

RELEASED
2012-09-04

NOTES:

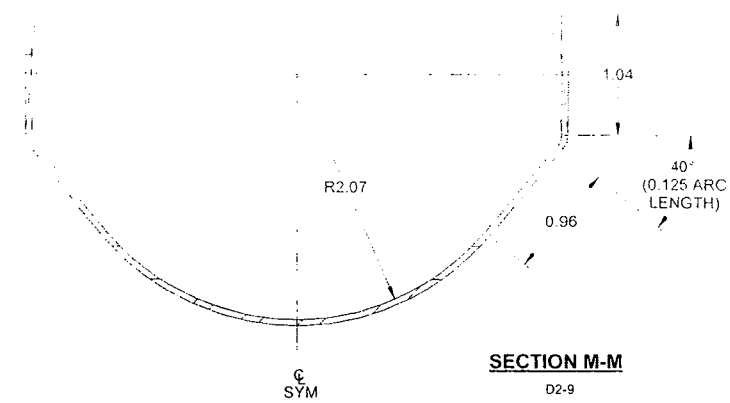
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.32 lbs

| | | | |
|------------|----------|---|---------------|
| DESIGN | RF | DART AEROSPACE USA, INC. | |
| DRAWN | PC | KENT, WA | |
| CHECKED | JS | DRAWING NO. | REV. D |
| MFG. APPR. | JS | D3849 | SHEET 9 OF 10 |
| APPROVED | JS | TITLE | SCALE |
| DE APPR. | JS | WEARPLATE ASSY | NTS |
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97781

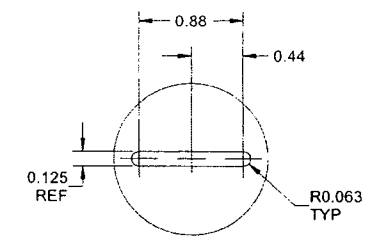
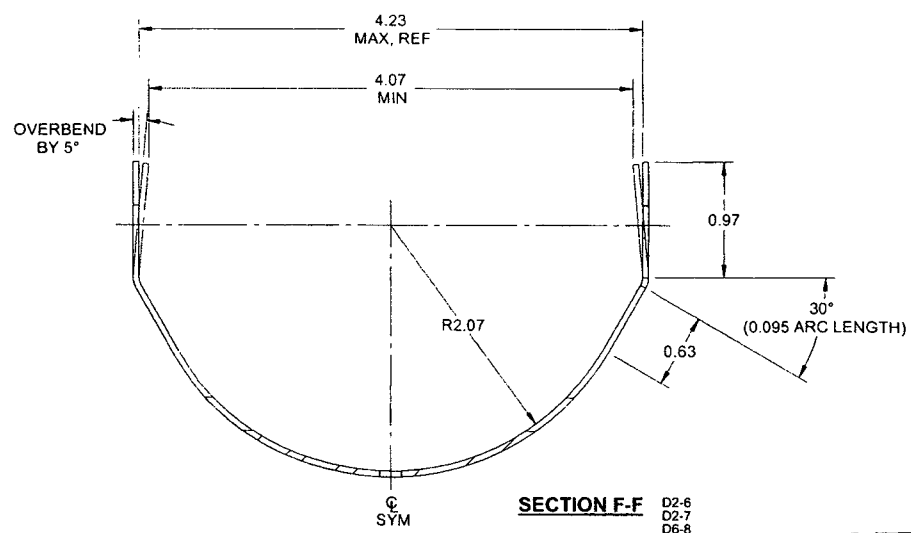
OVERBEND
BY 5°

1.17
MAX. REF
4.25
CART

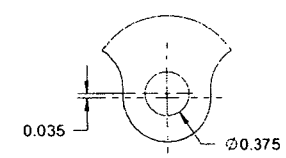


DETAIL G
SLOT DETAIL TYP

C4-6
C4-7
C4-8
C6-9



DETAIL H
SLOT DETAIL TYP
C3-6
B3-9



DETAIL L
DETAIL TYP
B2-8

RELEASED
R 2012-09-04
MP

| | | | |
|------------|----------|---|----------------|
| DESIGN | RF | DART AEROSPACE USA, INC. | |
| DRAWN | BC | KENT, WA | |
| CHECKED | ES | DRAWING NO. | REV. D |
| MFG. APPR. | ES | D3849 | SHEET 10 OF 10 |
| APPROVED | MP | TITLE | SCALE |
| DE APPR. | MP | WEARPLATE ASSY | NTS |
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